



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3510

Job Sheet 186243



Part No: 646.3510

Job Qty: 24 ea

Part Name: Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 11/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV N/C 3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	24 pcs		11/28/18	0.00	0.95	Waterjet - Flow		OK 18/11/18
120	QC	24 pcs		11/28/18	0.00	0.00	QC2 Waterjet-1		OK 18/11/18
130	QC	24 pcs		11/28/18	0.00	0.00	QC8-1		38
140	Small Fab	24 pcs		11/28/18	0.03	9.88	Small Fab-1		EC 9-89
150	QC	24 pcs		11/28/18	0.00	0.00	QC5		38
160	Large Fab	24 pcs		11/28/18	0.00	28.24	Large Fab 1		DAS 8
170	QC	24 pcs		11/28/18	0.00	0.00	QC9		24 CPC
180	QC	24 pcs		11/28/18	0.00	0.00	QC5		2-89 CPC
220	SprayPaint	24 pcs		11/28/18	0.00	0.89	Spray Paint		AS 19-2-1
225	Outsource	24 pcs		11/28/18			ATE003-VC	5	NRAS
230	QC	24 pcs		11/28/18	0.00	0.00	QC14		21
240	Packaging	24 pcs		11/28/18	0.00	0.00	Packaging3-1	CCS.103	87 FEB 20 2019
250	QC21-SA	24 Ea		11/28/18	0.00	0.00	QC21		21

Part Op 110 - 1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg Prog Rev: N/C 2-Debur if necessary

Descriptions: 140 - 1- Fabricate tube as per dwg USE DT10290 PUNCH

160 - Weld tube to plate as per dwg. DT9867 Weld end were tube is punch.

220 - Prime as per dwg (see note 3) Batch: S147812

240 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

FEB 21 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.6672 sf (.0278 ea)	110-Waterjet - Flow - 1	
M304TR0.500W.049	304 Round Tube .500 X .049W	19.9920 ft (.833 ea)	140-Small Fab	



Container No: S148903



Part: 646.3510

Job No: 186243

Serial No/Batch: S127740

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Required	Inventory	Allocated
1	197	0
20	124	0

s	Type	Special Comments
30		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

			2.720
2	Strut	1.500Inches $\pm$ 0.030	1.530 1.470
3	Strut	0.063Inches $\pm$ 0.010	0.073 0.053

Plex 11/13/18 10:34 AM Dart.lajeunesse.marie



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Date: 11/14/18

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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